

**Work Order ID 84045**

Tuesday, May 01, 2012 1:05:43 PM

**\*84045\***

Page 1

Item ID: D4327-1

Revision ID:

Item Name: Angle

Start Date: 5/1/2012 Start Qty: 1.00

Required Date: 5/4/2012 Req'd Qty: 1.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: mfDate: 12-05-01 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4327

A

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

2034.040

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.00

B12-5-2

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

B12-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84045

**\*84045\***

Tuesday, May 01, 2012 1:05:43 PM

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Item ID: D4327-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Angle

Stop **\*NS2\***

Start Date: 5/1/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/4/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

0.00

**\*130\***

Small Fab

Memo

0.00

Small Fab

Form as per dwg using DT9753 template

140

0.00

**\*140\***

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

*A MF 12-05-01*

*(3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*84045\***

Tuesday, May 01, 2012 1:05:43 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/1/2012      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 5/4/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** \_\_\_\_\_ **Start** \_\_\_\_\_ **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Chemical Conversion Coat per QSI005 4.1

0.00

**\*150\***

HandFinish

## Memo

0.00

## Hand Finishing

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location: 137

0.00

**\*170\***

## Packaging

## Memo

0.00

## Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 84045****\*84045\***

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Tuesday, May 01, 2012 1:05:43 PM

Item ID: D4327-1      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Angle  
Start Date: 5/1/2012      Start Qty: 1.00      **\*1\***      Cust Item ID:  
Required Date: 5/4/2012      Req'd Qty: 1.00      **\*1\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

MF  
12-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 01, 2012 1:05:43 PM

Page 1

Work Order ID: 84045

Parent Item: D4327-1

Parent Item Name: Angle

Start Date: 5/1/2012

Required Date: 5/4/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.03.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No				sf	219.4312		0.2463158			

1312-5-2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	219.4311626	
117684	21.318421	
120196	37.35	
120605	64.7627416	
121197	96	

121197

3

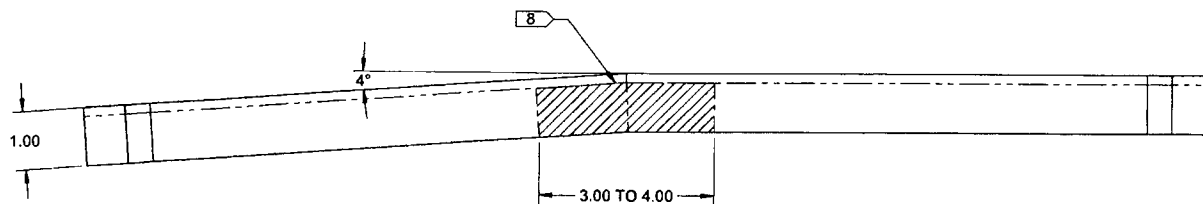
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

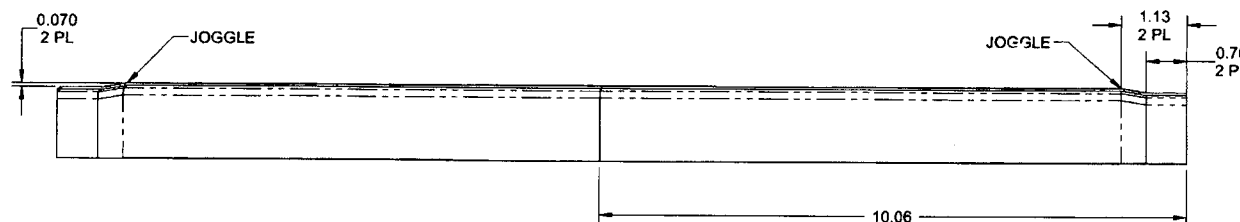
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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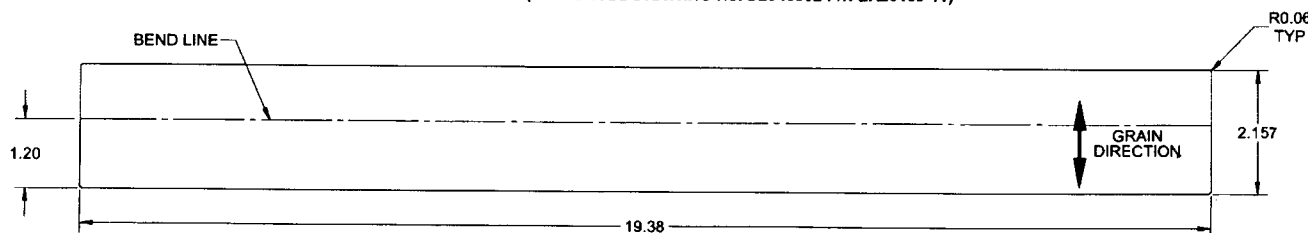
**NOTE:** Date & initial all entries



# 84045



**D4327-1 ANGLE**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)



**D4327-1F FLAT PATTERN**  
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037  
OR ASTM B209  
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs
- 8) SHRINKING AREA TO SUIT DT9753 TEMPLATE

**RELEASED**  
2011-04-06

A		NEW ISSUE		RF	10.11.22
REV		DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	RF	DRAWING NO. <b>D4327</b>		REV. A	
MFG. APPR.	RF	TITLE		SHEET 1 OF 2	
APPROVED	RF	VRD PARTS		SCALE	
DE APPR.	RF	DATE		NTS	
		10.11.22			

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W/O:		WORK ORDER CHANGES					
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 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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